		SPLOT
DART AEROSPACE LTD	Work Order:	21950
Description: Hi - Step Leg Assembly	Part Number:	D3065-041
Dwg: D3065 Rev. AZ	Qty:	60
PF 03-02-17 RF 03-02-28	180 to 190 to 19	Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	(Minimum lots of 30)	DO	04.11.23	60
2	MV	Cut blanks: 3.600" x 4.500" (grain along 4.500")  Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040)  Batch M 16584  Identify as D3065-1 4-320" RF 02.0.29 4.320"	5	05/01/14	60
3	MV	Cut blanks: 6.600" x 4.250" (grain along 4.320") 4.250") AT Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch M16584 (12-7) Identify as D3065-3	Ep	05/01/14	60
4	MV	Cut blanks: 4.580" x 4.500" (grain along 4.500")  Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040)  Identify as D3065-7	Sp	ostodiu	68
5	MV	Cut blanks: 16.61" x 8.51" (grain along 8.51") for each leg.  Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch M/674/ Identify as D3065-5 (Note: make 2 legs per assembly)	5	Stale	61
6	MV	Cut blanks: 16.490" x 0.750" for each spacer. (-0.00/+0.010)  Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick  (M5052H32S.080) Batch M1674/  Identify as D3066-1 M16765  (Note: make 2 spacers per assembly)	E	dalm	60
7	MV	Machine D3065-1 as per folio FA182 and Dwg D3065, use stack of 15.	Er	05/01/17	60
8	MV	Deburr to take measurement	En	05/01/17	66
9	QC2	Inspect parts as they come off the CNC machine	5	of oil 17	67
10	QC8	Second check	m	neloulis	60
11	MV	Machine D3065-3 as per folio FA180 and Dwg D3065, use stack of 15.	E	atolia	60
12	MV	Deburr to take measurement	G	05/01/17	66
13	QC2	Inspect parts as they come off the CNC machine	\$	dellir	60
14	QC8	Second check	End	05/0,/17	60
15	MV	Machine D3065-7 as per folio FA181 and Dwg D3065, use stack of 15.	27	05.01.17	III C
16	MV	Deburr to take measurement		05.01.17	PA H
17	QC2	Inspect parts as they come off the CNC machine		08,01.17	
18	QC8	Second check	~ 1	05/01/17	60
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	Er	05/01/17	120



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector				
ostaliz	上19	Step 19 shows up twice on the work order,	ph	05,03,09	MA	presin	A 05 03.09				

NCR:			WORK ORD	ER NON-CONFORMANO	CE (NCR)				
DATE STED	Description of NC	Corrective Action Section B			Description of NC		Varification	A	
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector	
			9						

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:		•
NOTE: Date & initial all entries				QA: I	V/C C	losed:	Date:	£1	

DART AEROSPACE LTD	Work Order:	21950
Description: Hi - Step Leg Assembly	Part Number:	D3065-041
Zf 05, 02.28	7 E E	
Dwg: D3065 Rev. At A2	Qty:	Coo
PF-03-02-17		Page 2 of 2

Step	Location	Procedure	Ву	Date	Qty
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	8	ostoilit	120
20	MV	Deburr to take measurement	En	05/01/17	120
21	QC2	Inspect parts as they come off the CNC machine	Es	ostalit	
22	QC8	Second check	The	reductiz	120
23	MV	Machine D3066-1 as per Folio FA280 and Dwg D3066, use stack of 10.	F	edoulis	60
24	MV	Deburr to take measurement	Gr	05/01/17	60
25	QC2	Inspect parts as they come off the CNC machine	Ep	octoby	60
26	QC8	Second check	ml	petalis	60
27	GA	Deburr D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1 stack.	mil	05-02-04	60/
28	GB	Bend D3065-1, D3065-3 & D3065-7 as per Dwg D3065	4	05.02.09	59
29	QC5	Inspect work to Step 28	1	05/02/09	59
30	FP	Chemical conversion coat as per QSI 005 4.; R 02.11.06 D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1	PD	05-02-22	
31	GA	Assemble as per Dwg D3065 and identify as D3065-041  Assembly.  Oty Part Number Description 1 D3065-1 Spacer 2 D3065-3 Spacer 2 D3065-5 Leg 1 D3065-7 Spacer \$30 874 \$31950 30 MS20470AD4-4 Rivet	SB	03/03/07	
32	QC5	Inspect work to Step 31	2	05:03:07	54
33	GA	Identify and Stock D3065-041 Hi-Step Leg Assembly D3066-1 Spacer	SB	05/03/67	54
34	AC	Cost / part 36,09	540	05.63.08	56
35	DC	Close W/O 3 6, 0 7 Inspect Level 21	+A	05.08.09	

Rev	Date	Change	Revised By	Approved
Α	01.12.10	New Issue	SM	mit.
В	02.09.10	Re-format; Incorporated D3065-1/-3/-5/-7	KJ	-1
C	02.11.01	Incorporated D3066-1 IPP	KJ RF	4



W/O:		WORK ORDER CH	ANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:	1950	WO	ORK OR	DER NON-CONFORMANC	E (NCR)	16		
		Description of NC Corrective Action Section B				Verification	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Design Mgr	QC Inspector
05-03.03	27	Found 1x 0 3065-3 spaces With a splanh in the hole	indo perces sur	Scrap it - No replace	ml	Bosca	Baranton	- 05000
05.01.08	28	1xD3065-1 center hole punched crooked causing a forack.	Andersen	Destray	J. 02.07	B 05.00.08	Per Gricus	8 000
	_							

Part No: <u>D3065-041</u>

PAR #: \_

Fault Category: MADORMISO NCR:

Yes No DQA:

QA: N/C Closed:

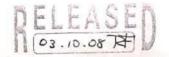
NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD	Work Order:	21950
Description: Step Spacer	Part Number:	D3065-1
Inspection Dwg: D3065 Rev: A2	1000	Page 1 of 1

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	0.250				
2.093	+/-0.010	2.094	1			
3.936	+/-0.010	3.233	2			
4.186	+/-0.010	4.190	-			
0.587	+/-0.010	0.590	_			
Ø0.128	+0.005 -0.000	0.128	_			
R0.125	+/-0.010	0.25	-			
3.465	+/-0.010	3.466				
Ø1.250	+0.005	1,250	_			
0.368	+/-0.010	0.369				
0.871 (Pitch)	+/-0.005	0.869				

Measured by:	6	Audited by:	me	Prototype Approval:	N/A
Date:	ostolly	Date:	05/01/12	Date:	03.10.08

Rev	Date	Change		Revised by	Approved
Α	03.09.22	New Issue	Plo D3065-041	KJ/RF	721

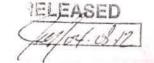


D3065-5DART AEROSPACE LTD	Work Order:	21950
Description: Step Spacer	Part Number:	D3065-3
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.260	+/-0.010	1,257	_			
3.260	+/-0.010	3.760				
5.260	+/-0.010	5.264	-			
6.520	+/-0.010	6.522				
2.093	+/-0.010	2.092	_			
3.936	+/-0.010	3.533				
4.186	+/-0.010	4.186	_			
Ø0.128	+0.005/-0.000	0.128	/			
Ø1.250	+0.005/-0.000	1.750	_			
Pitch 1.204	+/-0.005	1.703				
						Ř
	3.6					

Measured by:	CP,	Audited by:	girl.	Prototype Approval:	N/A
Date:	05/01/17	Date:	15/01/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.02.25	New Issue P/O D3065-041	KJ/RF	0 1
В	04.08.12	Removed dimension 1.204	KJ/JLM	1/10/1



D3065-5DART AEROSPACE LTD	Work Order:	21950
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16.458	~			
15.750	+/-0.005	15.750	_			
2.250	+/-0.005	2.250	/			
3.460	+/-0.005	13.459	_			
0.865	+/-0.005	0.861				
6.020	+/-0.005	6.019	-			
1.205	+/-0.005	1.707				
3.484	+/-0.005	3.480				
0.871	+/-0.005	0.867	-			
8.325	+/-0.010	8.323	/			
0.551	+/-0.010	,555				
0.213	+0.005/-0.000	, 213	~			
Ø0.128	+0.005/-0.000	.129	V			
				-		
				-		
			-			

Measured by:	ćr	Audited by:	me	Prototype Approval:	N/A
Date:	05/01/14	Date:	04/1/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.09.22	New Issue P/O D3065-041	KJ/RF	01
В	04.06.15	Added Ø0.128 dimension	KJ/JLM	2111



D3065-5DART AEROSPACE LTD	Work Order:	21950
•	1100	
Description: Step Spacer	Part Number:	D3065-7
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.000	6.128				
0.865 (Pitch)	+/-0.005	0.864	~			
4.522	+/-0.010	4.525	-			
0.250	+/-0.010	0.256				
2.093	+/-0.010	2.098				
3.936	+/-0.005	3.939				
4.186	+/-0.010	4.189	-			
Ø1.250	+/-0.005	1.750	_			
R0.125	+/-0.010	0.125	_			
Grain Direction	N/A	ok				
			J			

Measured by:	Er	Audited by:	50	Prototype Approval:	N/A
Date:	05/01/17	Date:	05,01.17	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.09.22	New Issue P/O D3065-041	KJ/RF	2/
В	04.05.15	Removed 0.531, 3.686, 0.580; Added 3.936 dimensions	KJ/JLM	Chell

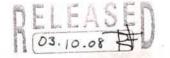
RELEASED 27.

D3065-5DART AEROSPACE LTD	Work Order:	21950	
Description: Spacer	Part Number:	D3066-1	
Inspection Dwg: D3066 Rev: A		Page 1 of 1	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005 -0.000	0.128	_			
0.708	+/-0.010	0.700/0.708	_			
0.358	+/0.010	0.350	_			
0.350	+/0.010	8.353	-			
2.250 (Pitch)	+/-0.005	2.750				
16.450	+/0.010	16450	~			
				F 8		
				y J	4	

Measured by:	CP	Audited by:	me	Prototype Appro	oval:	N/A
Date:	05/01/17	Date:	00/01/17	, C	Date:	03.10.08

Rev Date Change		Change		Revised by	Approved	
Α	03.09.22	New Issue	Plo D3065-041	KJ/RF	14	



#### Job Costing Report

Dart Aerospace Ltd. Hawkesbury

Nov 22, 2004 03:12 pm

Work Order No : 0021950 : D3065-041

Project Name : D3065-Project For : WK452 Work Order Type : Main

Main WO Number :

House Part Number: D3065-041

Description : Step Leg Assembly

Manufactured : Yes

Amount Req'd: 60 0 Amount Done :

: 11-22-04 Start Date Est Finish Date : 12-20-04

Act Finish Date : : No Drawings Reqd

Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNNN WO Status : Open

Invoice State : Not Invoiced

Invoice Date ': '

Invoice Number :

Invoice Amount :

Order Entry No :

OE Value :

Est Margin : 0.000% Actual Margin : 0.000%

\$0 Posted to Finished Goods

		Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00		
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00		
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00	E constant	
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00		
CNC	:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
		========	=======	======		
Burden	:	0.00	0.00	0.00		
3		=========		======		
Total Cost	:	0.00	0.00	0.00		
Margin	:	0.000	0.000		7	
Selling Cost	:	0.00	0.00			

Actual Estimated 0.00 0.00 Labour Hrs/Amount Done : Profits/(Loss) : 0.00